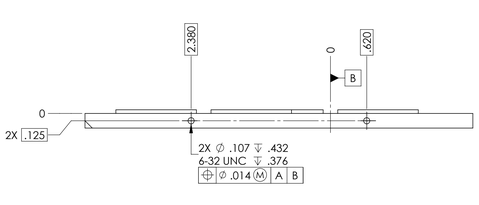
NOTES CONTINUED:

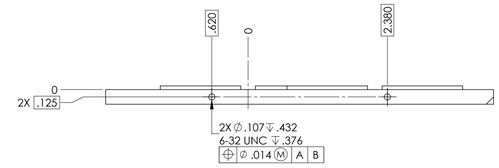
Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

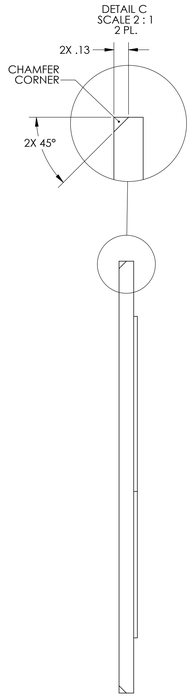
6. APPROXIMATE WEIGHT = .97 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

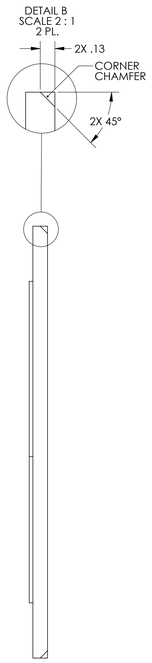
TYPE	DESCRIPTION
-01	X-ARM CONFIG.
-02	Y-ARM CONFIG.

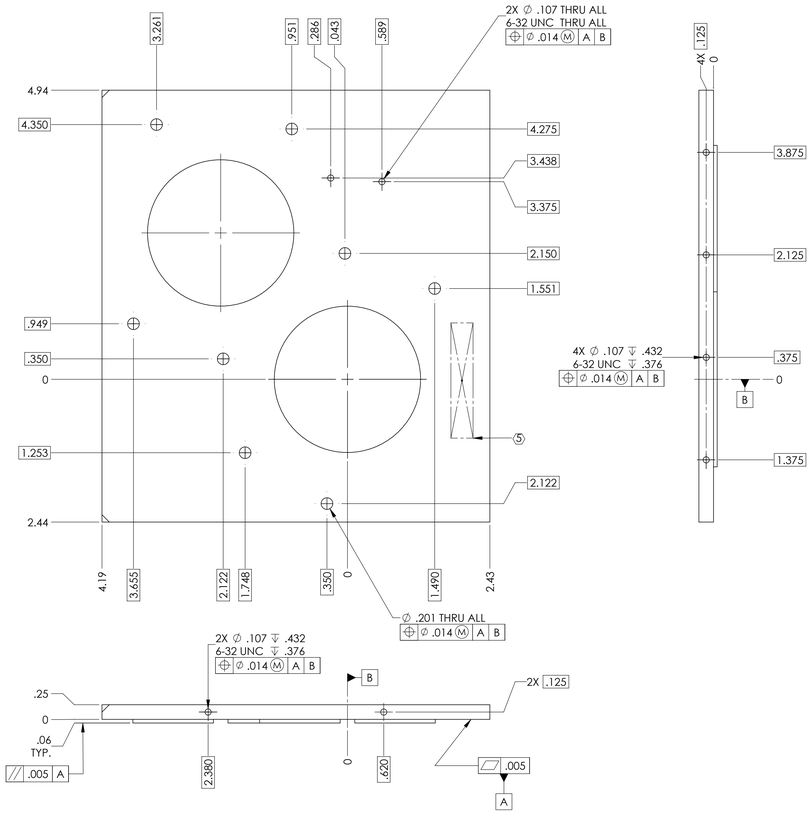
REV.	DATE	DCN #	DRAWING TREE #
v1	05 DEC 2012	E1200247-x0	E1200248-v1
-	-	-	-
-	-	-	-

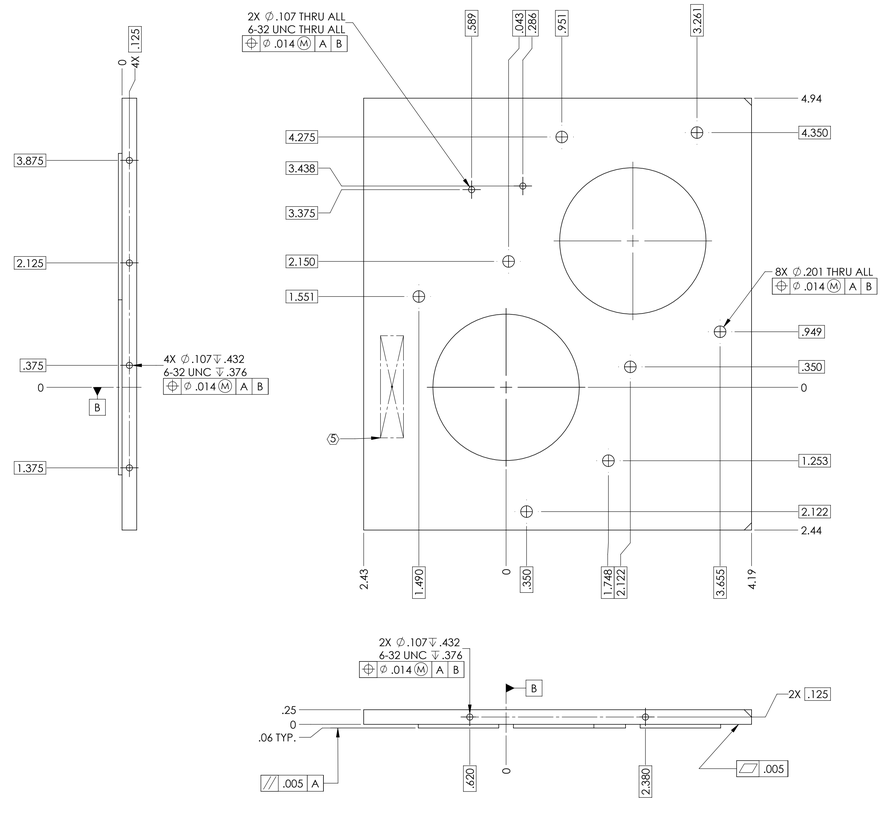


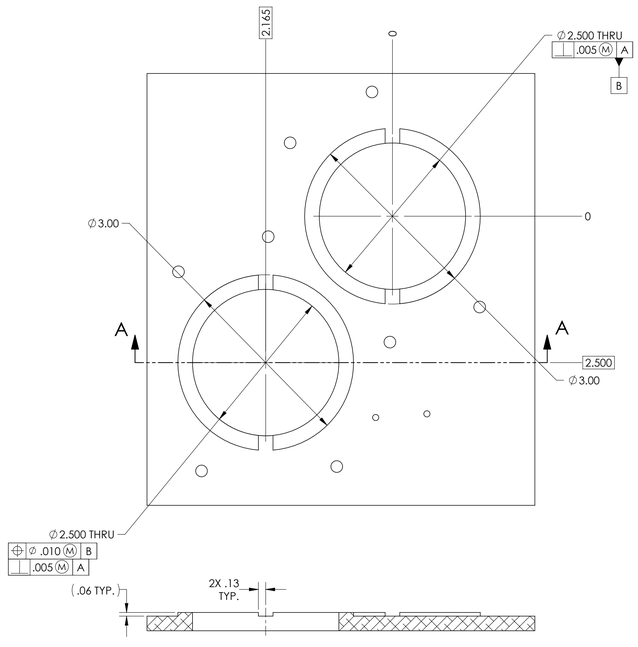


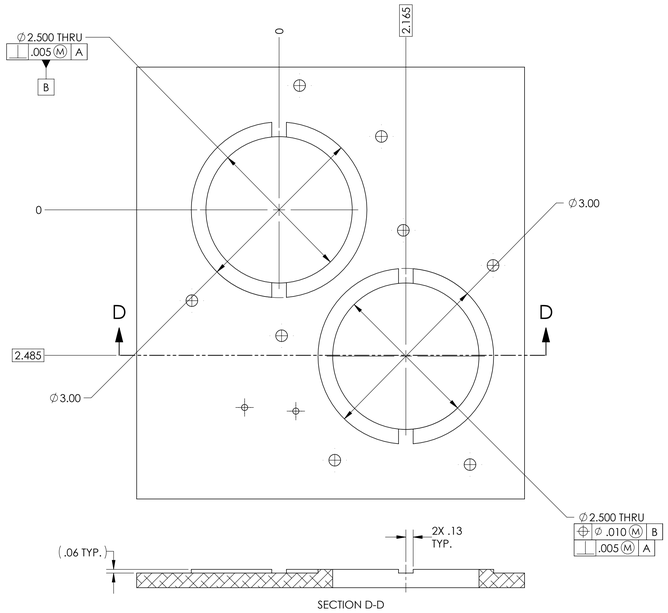












-01 DETAIL

-02 DETAIL

SECTION A-A

SECTION D-D

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY R.02. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				
MATERIAL: 6061 Alloy	FINISH: 63 µinch	LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: COVER, SECONDARY VIEWPORT CLAMP	
		SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: M. JACOBSON 19 SEPT 2012	SIZE: E
		NEXT ASSY: D1101627		DRAFTER: E.SANCHEZ 05 DEC 2012	DWG. NO.: D1201305
				CHECKER: M.JACOBSON 05 DEC 2012	REV.: v1
				APPROVAL: M.JACOBSON 05 DEC 2012	SCALE: 1:1 PROJECTION: SHEET 1 OF 1

D1201305_COVER, SECONDARY VIEWPORT CLAMP PART FROM REV: X-009, DRAWING FROM REV: X-002